

15

Date: Wednesday, 3/26/2008 9:52:16 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	BASKET LID ASSEMBLY		
Job Number	38158A						
Estimate Number	10853						
P.O. Number	:			Part Number	D3325041		
This Issue	: 3/26/2008	S.O. No. :		Drawing Number	D3325 REV B		
Prsht Rev.	: NC			Project Number	N/A		
First Issue	: / /	Type	LARGE FAB ASSY	Drawing Revision	B		
Previous Run	38157A			Material	:		
Written By				Due Date	4/11/2008	Qty:	1 Um: Each
Checked & Approved By	JD 08.3.26						
Comment	Est Rev:A 05.02.09 New issue KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33281	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2 D3328-1	Hinge Plate	B34123 ✓
2.0	D33491	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2 D3349-1	Spacer Bushing	B34205 ✓
3.0	D33521	Label Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2 D3352-1	Label Plate	B34206 ✓
4.0	D33671	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2 D3367-1	Mounting Bracket	B34207 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 38158A

Part Number: D3325041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M4130NTS0500W035 4130 Square tube .5 x .5



Comment: Qty.: 21.5687 f(s)/Unit Total : 21.5687 f(s)

Material: 4130 Cond. N Square tube per MIL-T-6736,

1/2" x 0.035" wall

M4130N-TS0.500W.035)

PD 08-03-28

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
2	D3325-1	EndTube	M104056 => 32"
3	D3325-3	Interior Tube	M104056 => 30"
2	D3325-5	Full Length Tube	M105533 => 171.5"

PD 08-04-03

Identify parts appropriately

2-Remove all markings from material

PD 08-04-03

3-Drill and Weld as per Dwg D3325 & QSI 004

A/RN/AS Steel Rod M100075

PL 08-04-04

4-Deburr as required

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/04/09

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/09 (G)

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/04/10

(X)

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Job Number:



Seq. #: Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



BL 08-04-10 Q

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PP 38158 RC 8/4/14

12.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/14 Q

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



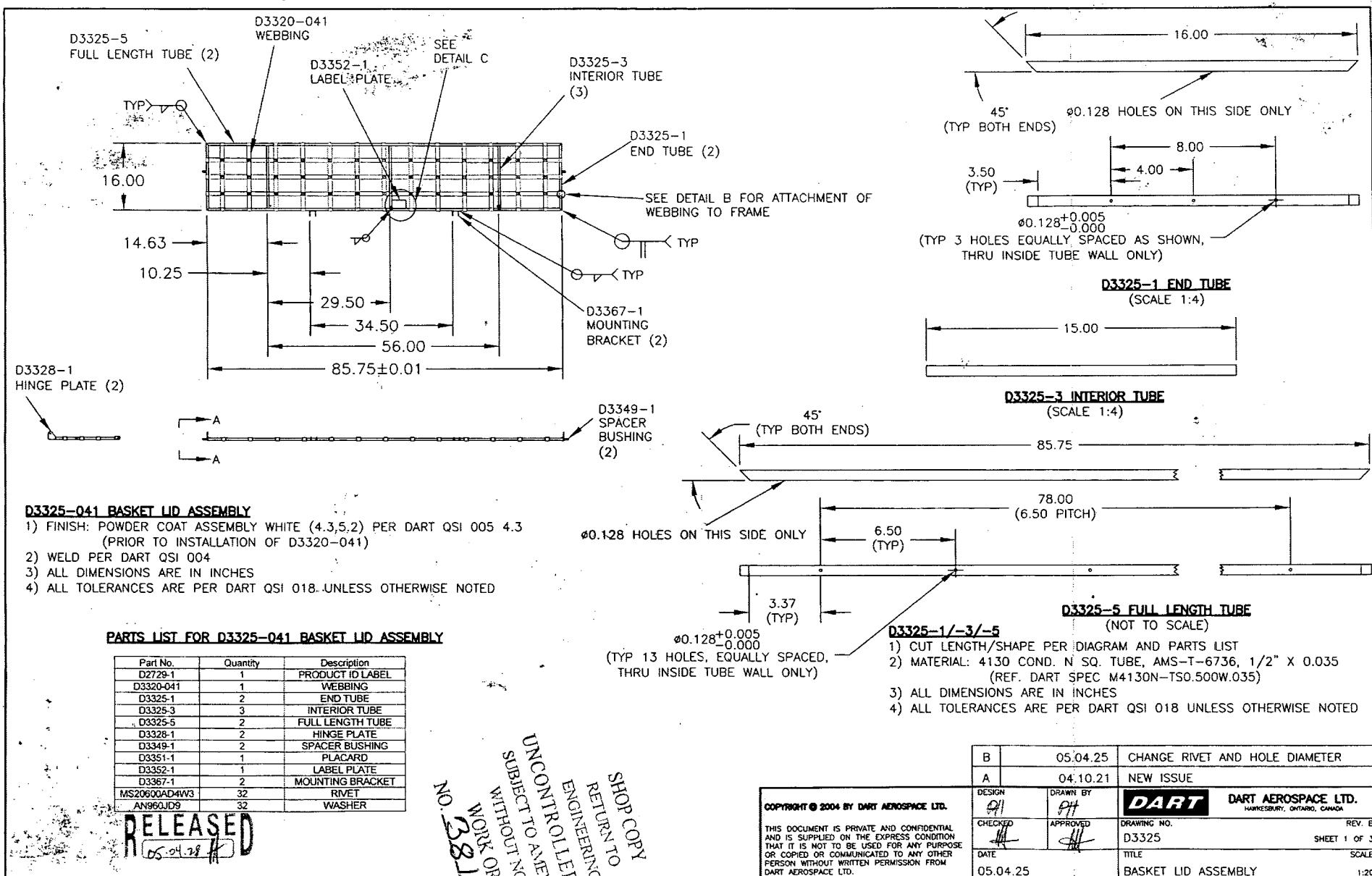
MF 08-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

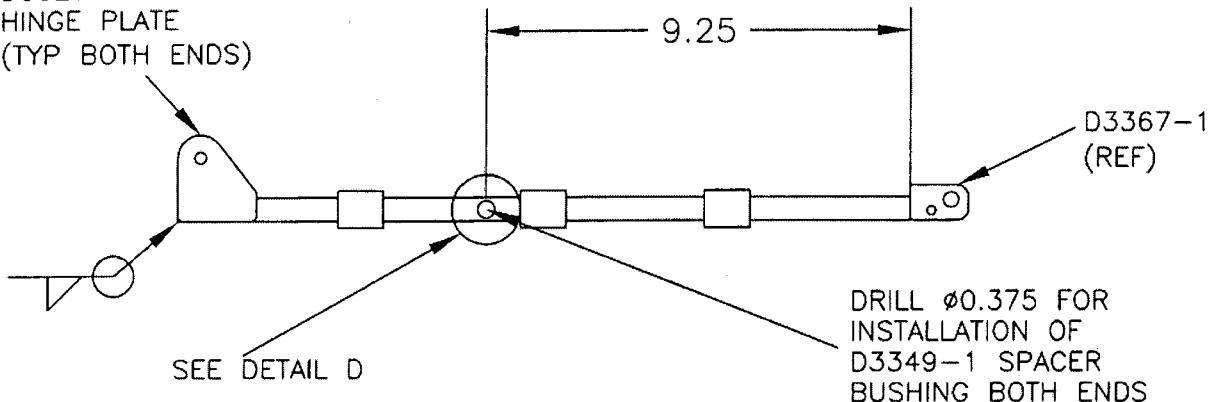
NOTE: Date & initial all entries



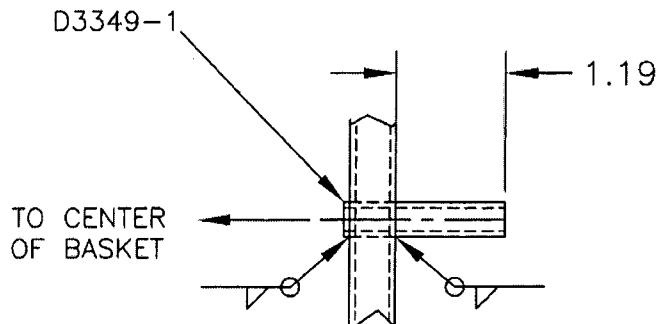


DESIGN <i>A1</i>	DRAWN BY <i>AH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>SH</i>	APPROVED <i>SH</i>	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

D3328-1
HINGE PLATE
(TYP BOTH ENDS)



VIEW A-A



DETAIL D
(SCALE 1:2)

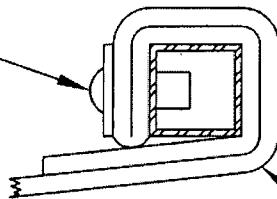
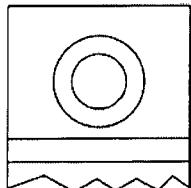
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38158A

RELEASED
05.04.25 *SH*

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)



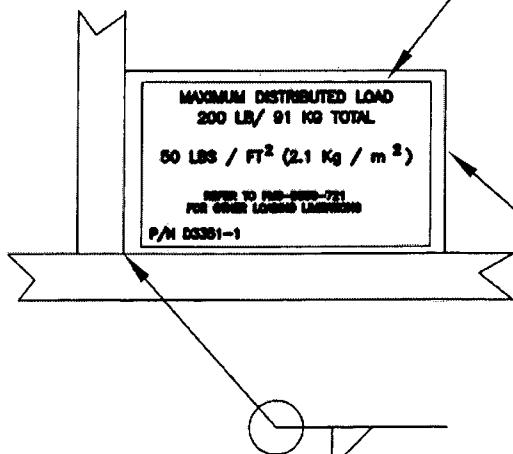
DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-041 WEBBING

RELEASED
05.04.28 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38158A

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1



OUTBOARD

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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